

M-309LSi

For austenite stainless steel (Low carbon, Dissimilar Steels)

Classifications

EN ISO 14343-B:2009	: SS 309LSi
AWS A5.9-2012	: ER309LSi
JIS Z 3321:2013	: YS309LSi

Approvals

Other	: TUV
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Description

- MIG welding of 22%Cr-12%Ni STS and dissimilar steels such as 304L to mild steels or low alloy steels
- Various applications of petrochemical and fiber power plant apparatus

Welding positions



Polarity & shielding gas

- DCEP (DC+)
- Ar + 1-3% O₂ (15 – 25 l/min)
- Ar + 1-5% CO₂ (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr
0.01	0.91	1.86	13.62	23.07

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	0 °C	-196 °C
AWS A5.9		Min. 520	Min. 30		
EN ISO 14343	Min. 320	Min. 510	Min. 25		
Example	435	609	39	114	56